

# Work Order ID 52213

September 18, 2009 11:36:52 AM



Page 1

Item ID: D3140-68

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler Kit

Start Date: 9/18/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*C. L. Murphy*

Date: 09/09/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

QC4- 100% Inspect kits for completeness

0.00

*0.00 50/10/01 ?*



QC

Memo

0.00

Quality Control

110

Identify as per dwg & Stock Location:

0.00

*ship to delastek*



Packaging

Memo

0.00

Packaging

120

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*C. L. Murphy 09/10/02*

# Picklist Print

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Work Order ID: 52213

Parent Item: D3140-68RevF

Parent Item Name: Doubler Kit

Comments:

Start Date: 9/18/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S D3140-10RevF Manufactured No

100 Each 1.0000 1.0000



Doubler Assembly

cu

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

50215

1

S D3140-101RevF Manufactured No

100 Each 5.0000 2.0000



Doubler

B50215

sp

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

50296

5

S D3140-241RevF Manufactured No

100 Each 5.0000 1.0000



Doubler

50296

sp

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

36731

5

36731

9/19/21

sp

@

# Picklist Print

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Work Order ID: 52213

Parent Item: D3140-68RevF

Parent Item Name: Doubler Kit



Comments:

Start Date: 9/18/09

Required Date: 9/25/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3140-303RevF		Manufactured	No			100	Each	3.0000	2.0000			
												
Doubler												



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
35158	3	

35158 SP

D3140-87RevF		Manufactured	No			100	Each	3.0000	1.0000			
												
Doubler												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
35155	3	

35155 SP

D3140-92RevF		Manufactured	No			100	Each	8.0000	1.0000			
												
Doubler												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
34374	2	
50384	6	

34374 9/19/09 SP @

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Shop Packet Print

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# Picklist Print

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Work Order ID: 52213

Parent Item: D3140-68RevF

Parent Item Name: Doubler Kit

Comments:

Start Date: 9/18/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3140-95RevF

Manufactured

No

100

Each

3.0000

3.0000

Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

34375

1

51723

2

D3140-98RevF

Manufactured

No

100

Each

5.0000

1.0000

Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

34376

5

D3140-99RevF

Manufactured

No

100

Each

0.0000

1.0000

Doubler

9/10/11

32065① SV

51723 2x 8

34376

SV

36761

9-9-21 (1x)

SV

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# Picklist Print

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Work Order ID: 52213

Parent Item: D3140-68RevF

Parent Item Name: Doubler Kit

Comments:

Start Date: 9/18/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3140-104RevF Manufactured

No

100

Each

4.0000

1.0000



Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

34378

4

100

Each

5.0000

1.0000

S D3140-106RevF

Manufactured

No



Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

34380

5

34378 SP

34380 9/19/21 SP (1x)

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Shop Packet Print

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**DART**

DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

**RELEASED**

06.11.13

52213

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED Jh	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

**RELEASED**

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND  
ALODINE PER DART QSI 005 4.1

F

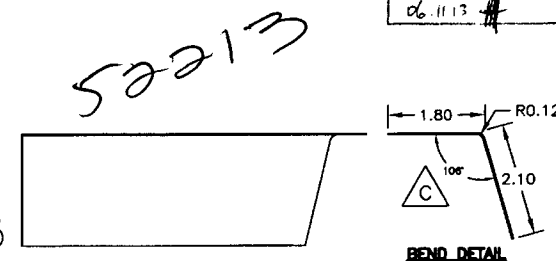
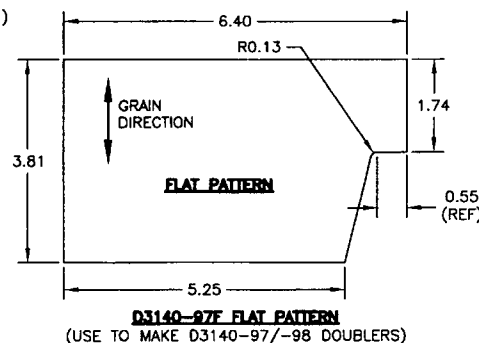
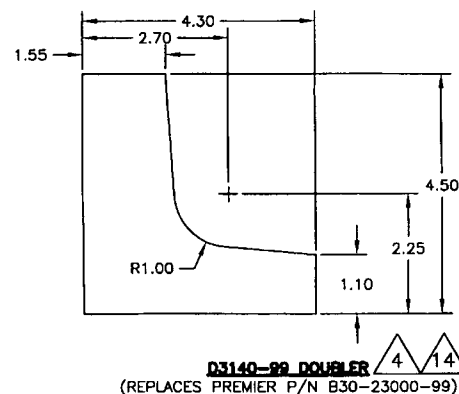
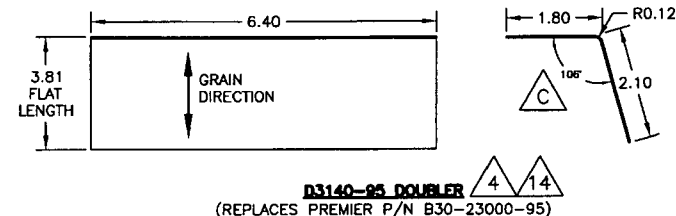
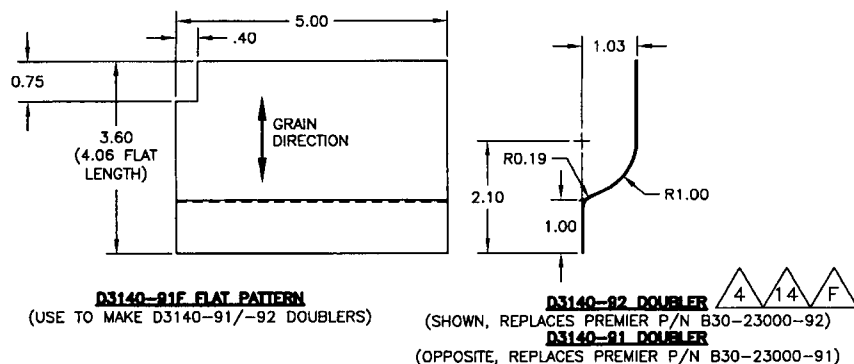
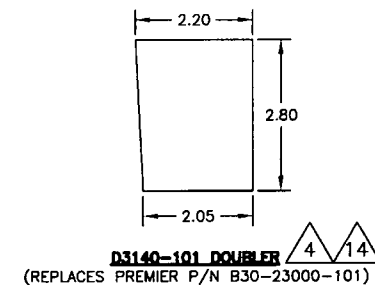
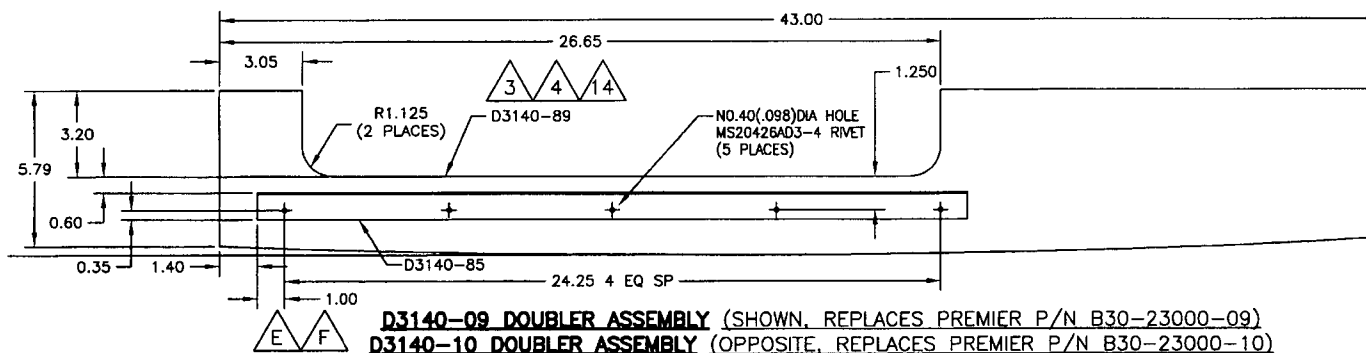
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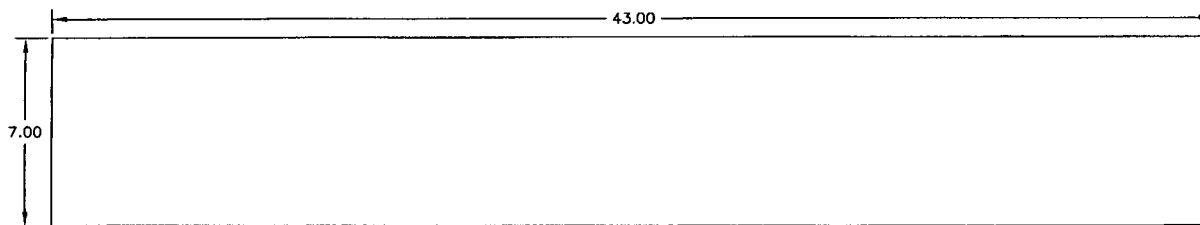




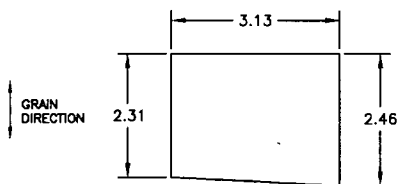
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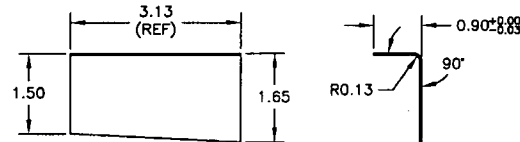
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CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	



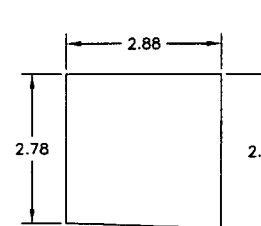
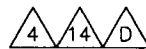
**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)



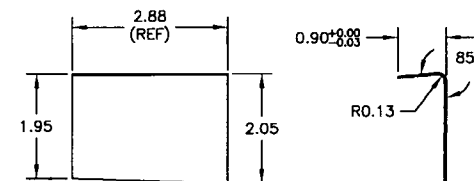
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)



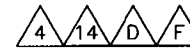
**D3140-105 DOUBLER**  
D3140-106 OPPOSITE



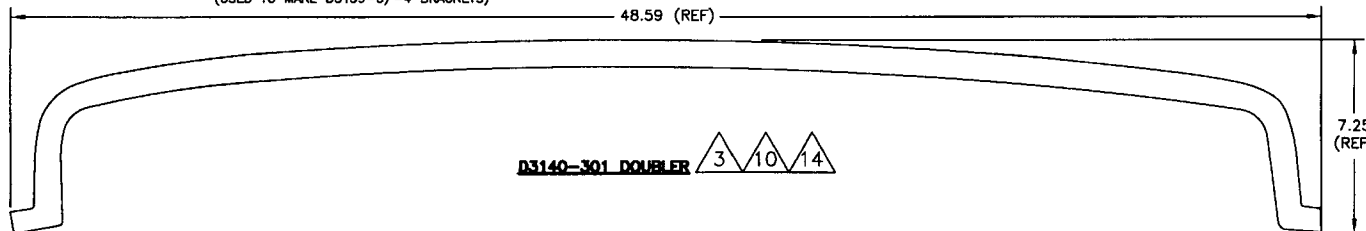
**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)



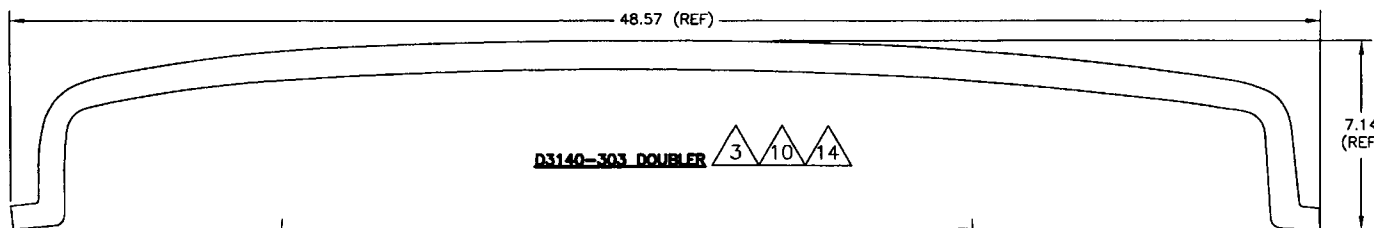
**D3140-104 DOUBLER**  
D3140-103 OPPOSITE



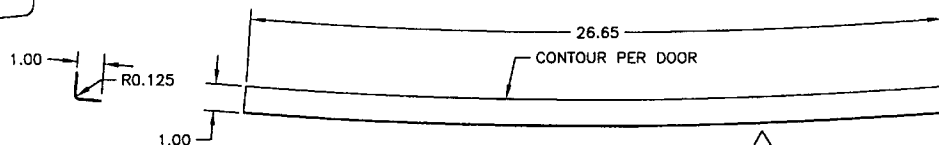
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**



**D3140-303 DOUBLER**



**D3140-85 ANGLE**   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

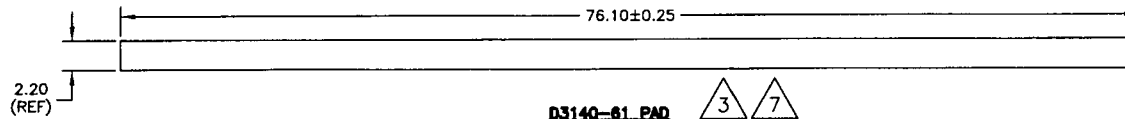
06.11.13

52213

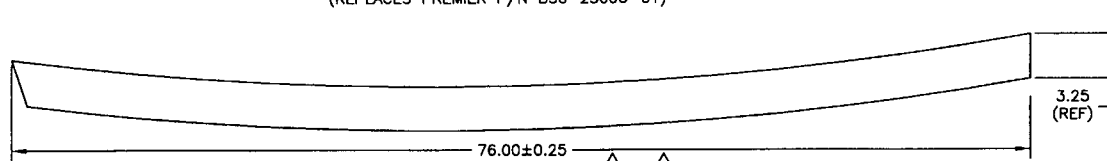
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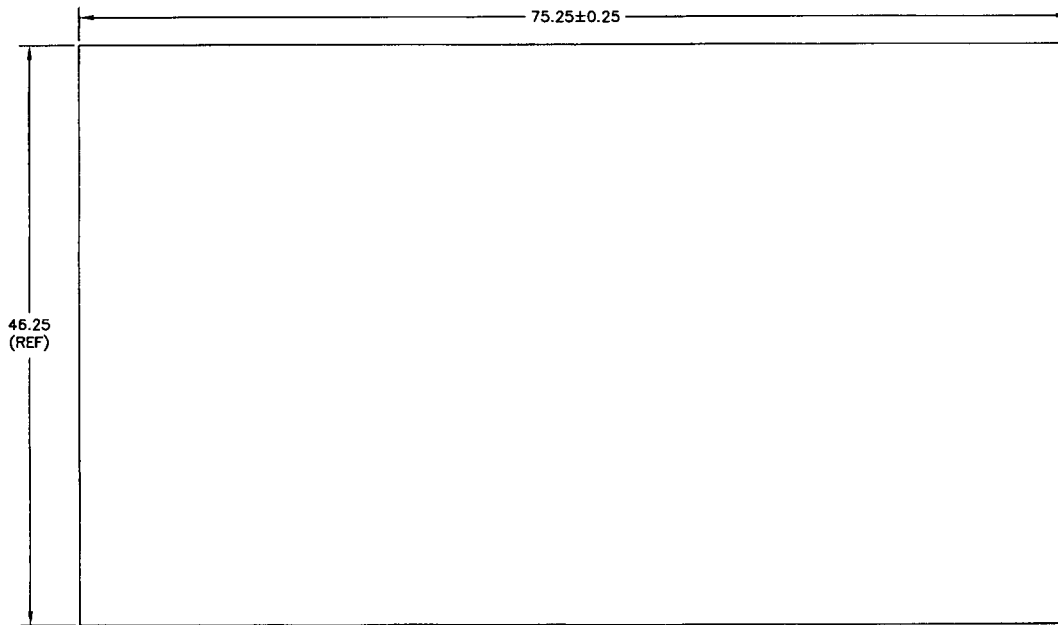
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. F SHEET 6 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	



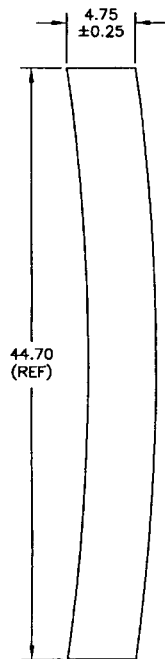
**D3140-61 PAD** 3 7  
 (REPLACES PREMIER P/N B30-23000-61)



**D3140-63 PAD** 3 7  
 (REPLACES PREMIER P/N B30-23000-63)

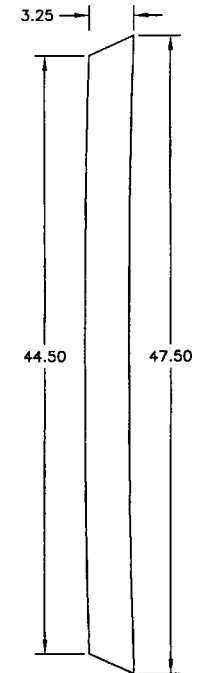


**D3140-59 PAD** 7  
 (REPLACES PREMIER P/N B30-23000-59)



**D3140-57 PAD**  
 (REPLACES PREMIER P/N B30-23000-57)

3 7



**D3140-241 DOUBLER** 5 14  
 (REPLACES PREMIER P/N B30-23000-241)

52213

RELEASED  
 06.11.13

R1.00  
 (2 PLACES, REF)

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CHECKED	<i>[Signature]</i>	APPROVED		DRAWING NO. D3140	REV. F SHEET 7 OF 7
DATE	06.10.06	TITLE	DOOR	SCALE	NTS

Dart Aerospace

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.	DATE 09/10/02
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO Delistek	
ADRESSE - ADDRESS		ADRESSE - ADDRESS	

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
	P/O: 10435	ATTN: Jacelyne		
1	D 3140-10	B 50215		
2	D3140-101	B 50296		
1	D3140-241	B 36731		
2	D3140-303	B 35158		
1	D3140-87	B 35155		
1	D3140-92	B 34374		
3	D3140-95	B 52265X1 B 51723X2		
1	D3140-98	B 34376		
1	D3140-99	B 36761		
1	D3140-104	B 34378		
1	D3140-106	B 34380		
thanks chantel.				
TPS/GST				
TVP/PST				
513990	SIGNATURE	N° LIC. - LIC. NO.	TOTAL	